**FIG. 1**

Membrane Configuration for EUR 2-C-5 Stack.

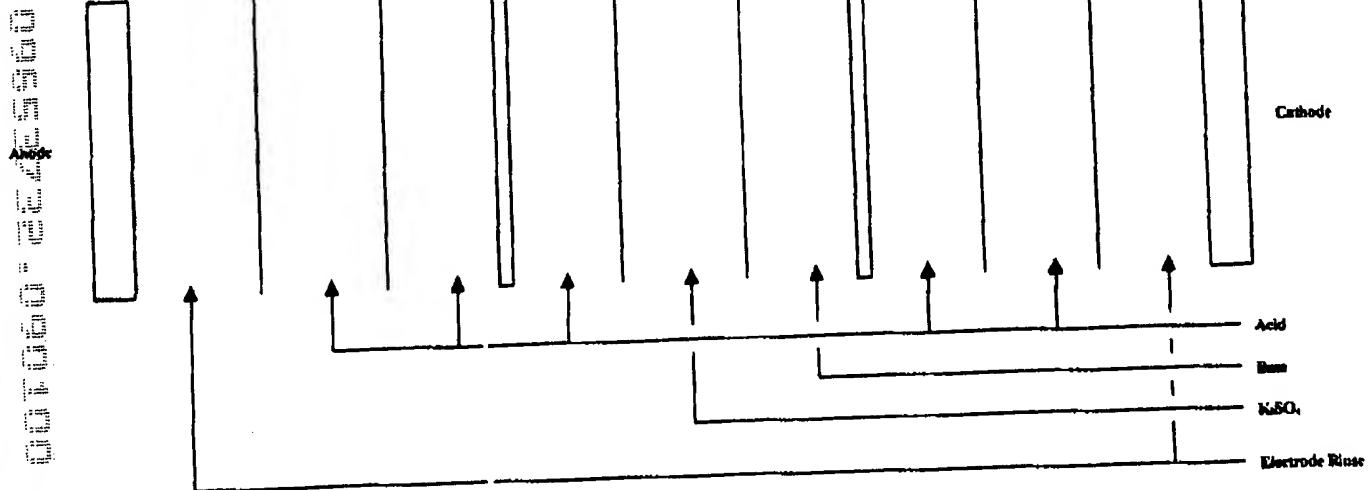


FIG. 2

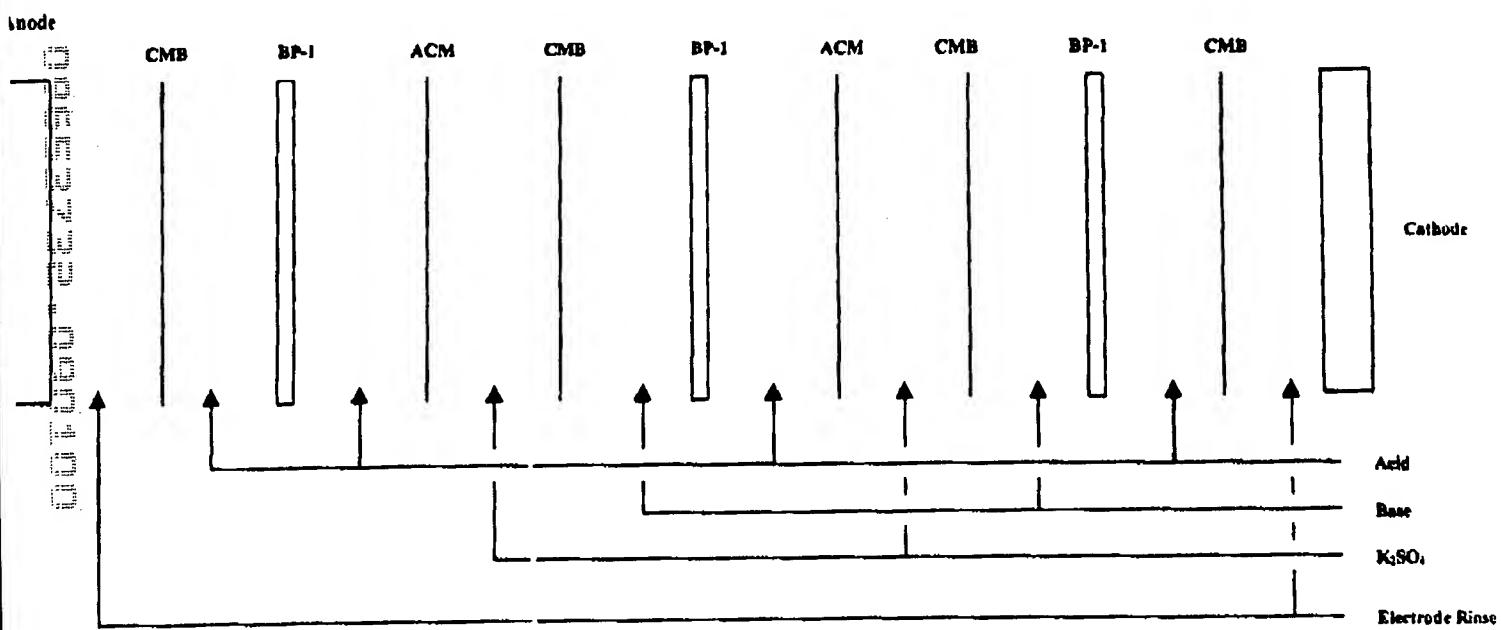
Membrane Configuration for ED-1 BP Stack.**FIG. 3**

FIG. 4

Summary of ED Runs (K_2SO_4 splitting)

Run#	Cell/Feed Source	Avg CD / V At Peak CD	Init Feed Sulfate Molar	Final Feed Sulfate Molar	Base CE %	Base Cone $M\text{ KOH} / mM SO_4$	Water Transport Into Base Mol/mol K ⁴	Acid CE %	Acid Conc Molar	SO ₄ Mass Balance %
484-2	EUR 2-C-5 / Crystal	84 / 14.4	0.53	0.33	84	2.28 / 3.8	2.0	74	1.0	99
484-6	EUR 1-C-5 / Crystal	148 / 162	0.75	0.54	87	2.54 / 1.1	3.3	82	1.1	98
484-22	ED-1 BP / Crystal	187 / 13.5	0.70	0.485	84	2.62 / 1.1	3.9	76	1.35	103
484-27	ED-1 BP / Crystal	162 / 13.3	0.635	0.375	86	3.55 / 1.6	3.1	65	1.33	99
484/31	ED-1 BP / Hi Na Soln	48/20	0.602	0.527	82	1.23 / 2.1	3.2	50	0.67	96

FIG. 5

Summary of ED Runs (K_2SO_4 splitting)

Run #	K:Na Mole Ratio in Feed	K:Na Mole Ratio in Base	Partition Coefficient across CMB Membrane K vs Na	Diffusion Coefficient SO_4 m^2/sec	Diffusion Coefficient K into Acid m^2/sec
484-2	-	-	-	6.0×10^{12}	2.1×10^{12}
484-6	-	-	-	1.9×10^{12}	3.1×10^{12}
484-22	6405:1	5468:1	0.9	2.3×10^{12}	2.4×10^{12}
484-27	8596:1	9561:1	1.1	2.5×10^{12}	1.6×10^{12}
484-31	57:1	45:1	0.8	2.8×10^{12}	1.2×10^{12}

Summary of Analytical Results for ED Runs

FIG. 6

Run	Initial Feed [Na] / [SO ₄] / pH	Final Feed [Na] / [SO ₄] / pH	Initial Base [Na] / [OH] / [SO ₄]	Final Base [Na] / [OH] / [SO ₄]	Initial Acid Mg/L / M / M	Final Acid Mg/L / M / M	[SO ₄] / {K}	[SO ₄] / {K}	Final Acid M / mg/L
484.6	15 / 0.528 / -	21 / 0.332 / 1.7	1 / 0 / 0	133 / 2.28 / 0.0038	0.5 / 11	1.0 / 127			
484-6	9 / 0.750 / 7.5	13 / 0.542 / 2.4	2 / 0 / 0	49 / 2.54 / 0.0011	0.5 / 11	1.1 / 159			
484-22	5.5 / 0.698 / 8.5	3.2 / 0.485 / 1.8	0 / 0 / 0	20 / 2.62 / 0.0011	0.582 / 11	1.35 / 1237			
484-27	3.6 / 0.635 / 7.5	1.9 / 0.375 / 1.4	0 / 0 / 0	20 / 3.55 / 0.0016	0.472 / 11	1.33 / 1084			
484-31	511 / 0.602 / 10.3	403 / 0.527 / 2.0	0 / 0 / 0	349 / 1.23 / 0.0021	0.486 / 11	0.665 / 783			

Summary KOH Electrolysis

FIG. 7

Run #	CD/V mA/cm ² / V	Charge Passed F	Unit Anolyte [OH] M	Unit Catholyte [OH] M	Final Catholyte [OH] M / %	Cathodic CE %	K:Na mole Ratio in Anolyte	K:Na mole Ratio Transported across Membrane	Partition Coefficient For K vs Na	
									7/8	7/8
484.11	200 / 4.6	2.75	2.54	0.1	4.37 / 20.4	98.6	1544:1	6273:1	4.1	
484-15	340 / 5.6	2.48	2.52	4.05	7.45 / 32.0	98.7	1617:1	5457:1	3.4	

FIG. 8

Summary of Analytical Results for Electrolysis Runs

RUN #	Initial Anolyte [OH] / [Na] M / mg/L	Final Anolyte [OH] / [Na] M / mg/L	Initial Catholyte [OH] / [Na] M / mg/L	Final Catholyte [OH] / [Na] M / mg/L
484-11	2.54 / 29	1.18 / 25.3	0 / 0	4.37 / 16
484-15	2.52 / 29.4	1.38 / 25.8	4.05 / 19.4	7.45 / 33.6